



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4091-1

Job Sheet 169705



Part No: D4091-1

Job Qty: 50 ea

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/19/17

Job Tracking No:

Due Date: 1/5/18

Created By: Linda Lacelle

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	50 pcs		1/5/18	0.00	0.00	Purchasing		Chad 22-12-17
110	Packaging	50 pcs		1/5/18	0.00	0.00	Packaging2		Chad 22-12-17
130	QC	50 pcs		1/5/18	0.00	0.00	QC6		DAS 38 DEC 23 2017
160	QC	50 pcs		1/5/18	0.00	0.00	QC3		38 DEC 23 2017
170	Packaging	50 pcs		1/5/18	0.00	0.00	Packaging3-2	57525	9-80
180	QC21-SA	50 Ea		1/5/18	0.00	0.00	QC21		JAN 02 2018
Part Op 100 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005									
Descriptions: DEC 20 2017 DAS 13 P10: 38688									

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	D2423	6	844	0	0
	D4091-1P	50	40	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By

Job No: 169705
Mfg Date: 12/22/17

Purchasing

D4091-1

Change No:

Operation:

Revision:

PART NO:

Mounting Lug

id hand / Supervisor
approval VerificationC / QA Coordinator
Approval

Root Cause			
Environment ☐	No Re-verification ☐	Pressu ☐	
Design ☐	Operator ☐	Bendir ☐	
Doc/Data ☐	Offset/Setup ☐	Centre ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp, ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	
Internal Transport ☐	Poor Information ☐	Crushi ☐	
Tribal Knowledge ☐	Rushing ☐	Heat T ☐	
LOA ☐	Product Improvement ☐	Wave/ ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		
		OTHER :	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



S026719
AEROSPACE
DART

☐ Drill Holes☐ Misaligned/off center☐ Turning Sequence

ositioned Wrong
outside Dimensions
Iver/Under tolerance
art Incorrect
art Lost/Missing
art Moved
rawing
inish
/isread

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	1.380Inches ± 0.030	1.410 1.350		
2	Mounting Lug	4.450Inches ± 0.030	4.480 4.420		
3	Mounting Lug	0.270Inches ± 0.030	0.300 0.240	Reference	
4	Mounting Lug	1.910Inches ± 0.030	1.940 1.880		
5	Mounting Lug	0.690Inches ± 0.030	0.720 0.660		
6	Mounting Lug	0.293Inches ± 0.010	0.303 0.283		
7	Mounting Lug	0.735Inches ± 0.010	0.745 0.725	Reference	
8	Mounting Lug	0.375Inches ± 0.010	0.385 0.365		
9	Mounting Lug	3.700Inches ± 0.010	3.710 3.690		
10	Mounting Lug	0.625Inches ± 0.010	0.635 0.615		
11	Mounting Lug	0.375Inches ± 0.010	0.385 0.365		
12	Mounting Lug	0.257Inches ± 0.006 - 0.001	0.263 0.256	Diameter	
13	Mounting Lug	0.400Inches ± 0.030	0.430 0.370	Radius	
14	Mounting Lug	2.310Inches ± 0.010	2.320 2.300	Reference	

153
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DQA: _____ Date: _____

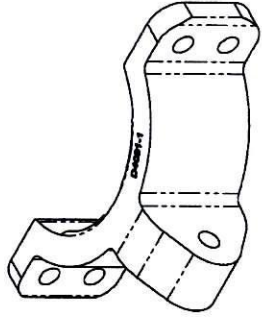


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



D4091-1 MOUNTING LUG

RELEASED
R 2010-04-24

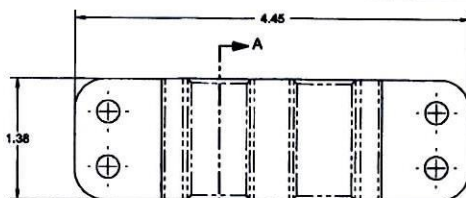
- NOTES:
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
 - 3) TOLERANCES: UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.016 ± 0.005
 - 7) WEIGHT: 0.31 lbs

A		NEW ISSUE		CP		10.03.29	
REV.	DESCRIPTION	CP	BY	DATE			
DESIGN	DART AEROSPACE LTD						
DRAWN	NUMBERSBY ONTARIO CANADA						
CHECKED	OSWING INC.						
INSTR. APPL.	D4091				REV. A	SHEET 1 OF 2	
APPROVED	TITLE				SCALE	DATE	10.03.29
DE APPL.	MOUNTING LUG				DATE	10.03.29	
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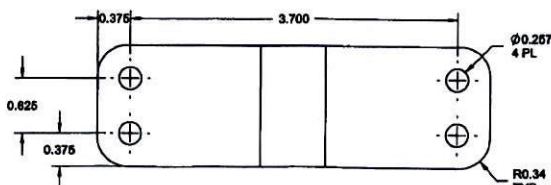
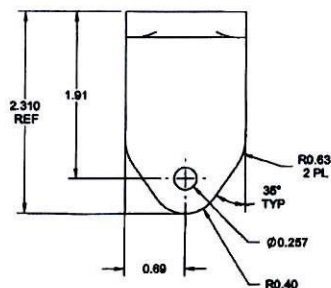
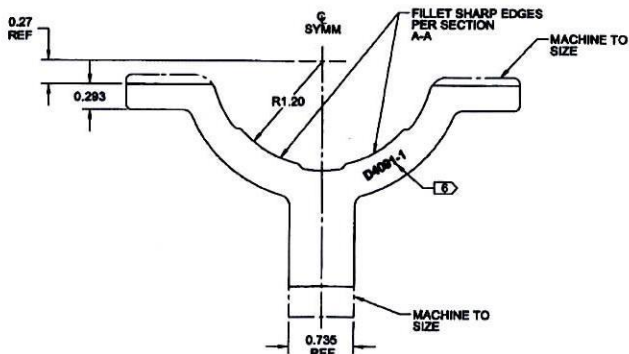


R0.03-R0.07
TYP AROUND PAD

SECTION A-A
C6-2



A
C7-2



D4091-1 MOUNTING LUG

RELEASED
2010-04-20
M/D

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWTHORNE, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4091	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE MOUNTING LUG	SCALE
DE APPR.			NTS
DATE	10.03.29	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS UNCLASSIFIED INFORMATION AND IS NOT TO BE RELEASED TO THE PUBLIC WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	

12/20/2017

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038688

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

PO No: PO038688**PO Date:** 12/20/17**Due Date:** 12/21/17**Purchase Order****Revision:****Revision Date:****Ship-To Contact:** Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
DEC 20 2017

Attention: Walz, Shigi**Via:** Ground**Pynt Terms:** Net 30**Freight Terms:****Special Comments:** QUOTE # 5723

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D4091-1P			Lug	Firmed	12/21/17	50 pcs	0 pcs	50 pcs	\$16.10/pcs	\$805.00
Line Item Note AS PER DWG D4091 REV. A B169710 ALODINE AND PAINT AS PER QSI 005											
2	D3338-1P			Mounting Lug	Firmed	12/21/17	40 pcs	0 pcs	40 pcs	\$20.60/pcs	\$824.00
Line Item Note AS PER DWG D3338 REV. A B169710 ALODINE AND PAINT AS PER QSI 005											
Grand Total:										\$1,629.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 22237
Date: Dec 20, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO038688	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Dec 20, 2017

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D4091-1 Lug as per drawing D4091 Rev.A Alodine and Paint as per QSI 005		Each	50	50	
D3338-1 Mounting Lug Alodine and Paint as per QSI 005		Each	40	40	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____			Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3338-1	Lug Paint Batch # 21012 Material B148835	38688
50	D4091-1	Lug Paint Batch # 21095 Material B148835	38668

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, December 21, 2017